



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB T101338-3
Job Sheet 169271



Part No: RB T101338-3

Job Qty: 3 pcs

Part Name: Jack Screw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/6/17

Job Tracking No:

Due Date: 10/31/17

Created By: Diane Baker

Type: Stock

Description:

Ship Via: *Rev A*

*DAS
03
9-89*

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		10/30/17	0.00	0.00	Start Up Large Fab-3		<i>JS</i>
110	Large Fab	3 pcs		10/31/17	0.00	0.50	Large Fab 4		<i>JS</i>
120	QC	3 pcs		10/31/17	0.00	0.00	QC9		<i>EL</i>
121	QC	3 pcs		10/31/17	0.00	0.00	QC5		<i>EL</i>
122	Outsource	3 pcs		10/31/17			GRO002-VC <i>Outsource 3</i>		<i>AT 18/02/14</i>
123	Packaging	3 pcs		10/31/17	0.00	0.00	Packaging2		<i>AT 18/02/14</i>
124	QC	3 pcs		10/31/17	0.00	0.00	QC6		<i>38</i>
130	Packaging	3 pcs		10/31/17	0.00	0.00	Packaging3 Large Fab <i>GA.</i>		<i>FEB 16 2018</i>
140	QC21-SA	3 Ea		10/31/17	0.00	0.00	<i>N</i> QC21		<i>21</i>
180	QC	3 pcs		10/31/17	0.00	0.00	QC5		<i>21</i>

Part Op 110 - Weld as per dwg. Us DT10360 welding fixture.

Descriptions: 122 - Issue P/O to Groupe Altech: P/O *38767* -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required
130 - Bag and tag

JAN 1 1 2018

*DAS
13
9-89*

FEB 23 2018

Oper:
90-St

DART
AEROSPACE
S030592



Jack Screw

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

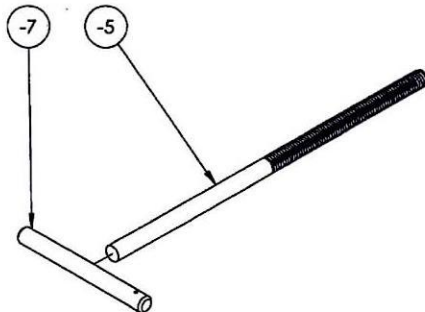
Qty

esse.marie

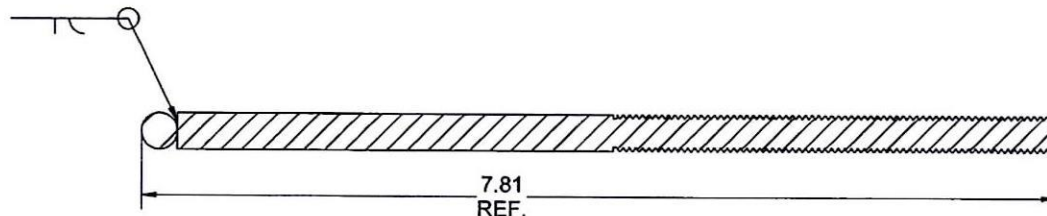
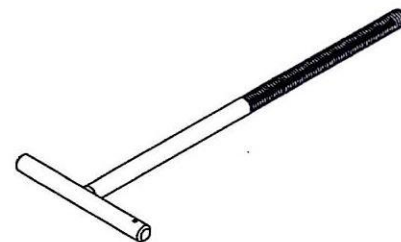
PART NO: RB T101338-3
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 01/09/18
Job No: 169271

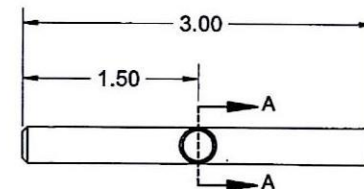
ITEM #	QTY	PART #	TITLE	PG
-5	1	RB T101338-5	SCREW HANDLE	3
-7	1	RB T101338-7	HANDLE	4



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 169271 MJS
17-12-20



SECTION A-A



RB T101338-3 JACK SCREW

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATED
- 4) SPEC: ASTM B633 TYPE I, SC2
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE JACK SCREW	
DWG NO. RB T101338-3	
DESIGN BY: VM 8/30/2017	XXX ± .005 FRACTIONS & 1/8
DRAWN BY: VM 10/30/2017	XX ± .01 ANGLES & 5°
CHECKED: SAC 10/30/2017	± .1 SURFACES = 12°
MFG. APPR: DD 10/31/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
APPROVED: UWM 12/08/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE: 10/30/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE: NTS	WEIGHT: N/A
SHEET 2 OF 4	
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DQA: _____ Date: _____



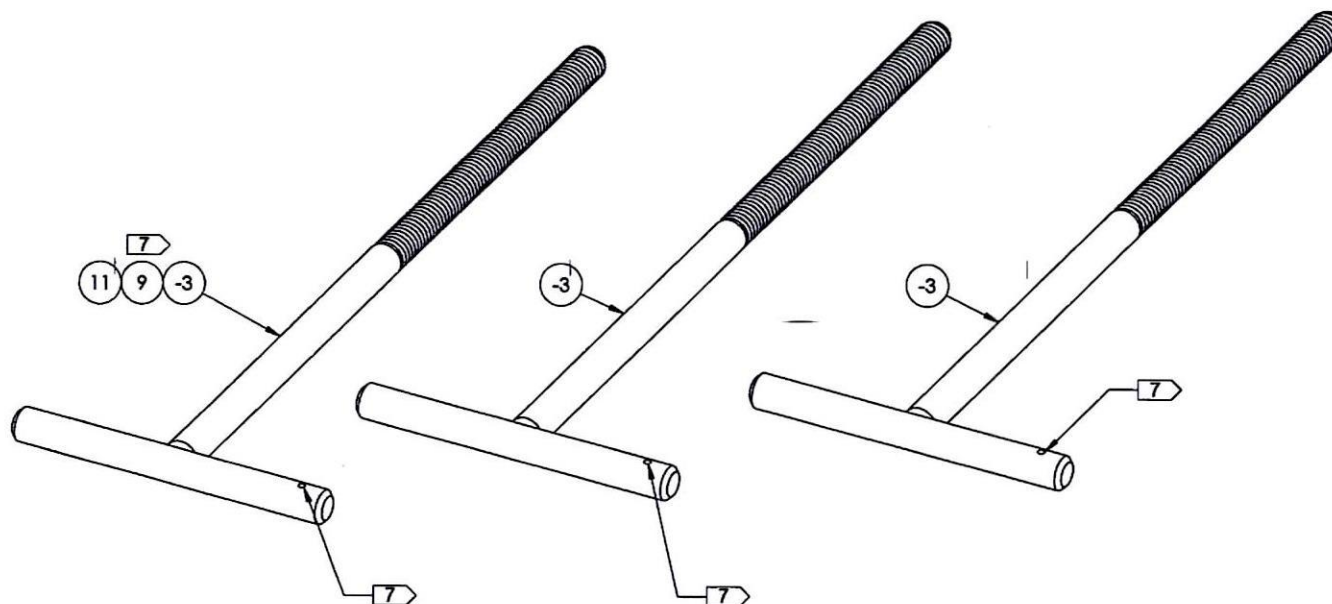
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

ITEM #	QTY	PART #	TITLE	PG	REV.	DESCRIPTION	DATE	BY	APPROVED
-3	3	RB T101338-3	JACK SCREW	2	A	NEW ISSUE	17.08.30	VM	WM
9	A/R	MS20995-C32	LOCKWIRE	-					
11	3	McMaster#1632T22	TAG	-					



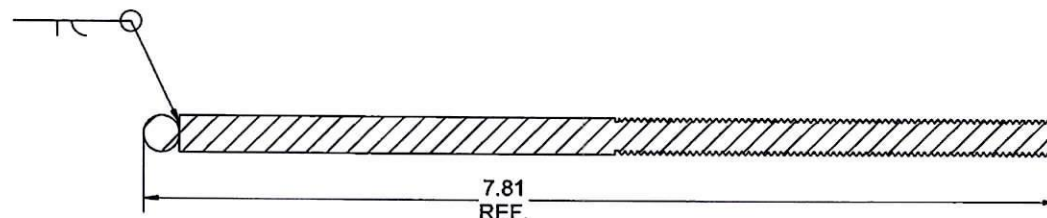
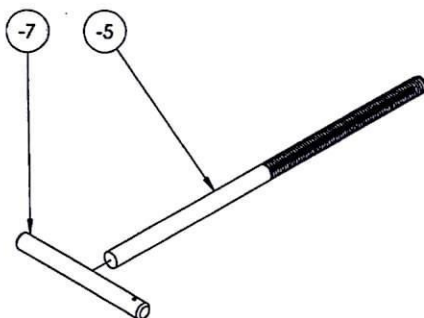
RB T101338 JACK SCREW SET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) HEAT TREAT: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE P/N & S/N ITEM# 11
- 7) ITEM# 9 LOCKWIRE JACK SCREWS TOGETHER AND TAG (ITEM# 11)
- 8) REF. BELL T/N: T101338

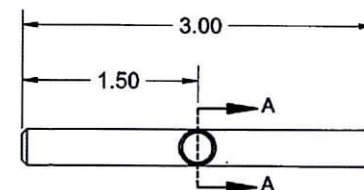
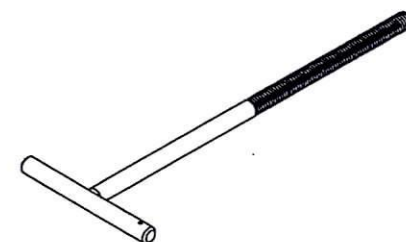
DART AEROSPACE Newbury, Ontario, Canada	
TITLE JACK SCREW SET	
DWG NO. RB T101338	
REV A	
DESIGN BY: VM 8/30/2017	XXX 2 .005 FRACTIONS & 1/8
DRAWN BY: VM 10/30/2017	XX 2 .01 ANGLES 2.5°
CHECKED: SAC 10/30/2017	X .1 SURFACES = 12.5°
MFG. APPR: DD 10/31/2017	1. DIMENSIONS ARE IN INCHES
APPROVED: VM 12/06/2017	2. UNLESS OTHERWISE SPECIFIED
DATE: 10/30/2017	3. DIMENSIONAL LIMITS APPLY
SCALE: NTS	WEIGHT: N/A
SHEET 1 OF 4	
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ITEM #	QTY	PART #	TITLE	PG
-5	1	RB T101338-5	SCREW HANDLE	3
-7	1	RB T101338-7	HANDLE	4



SECTION A-A

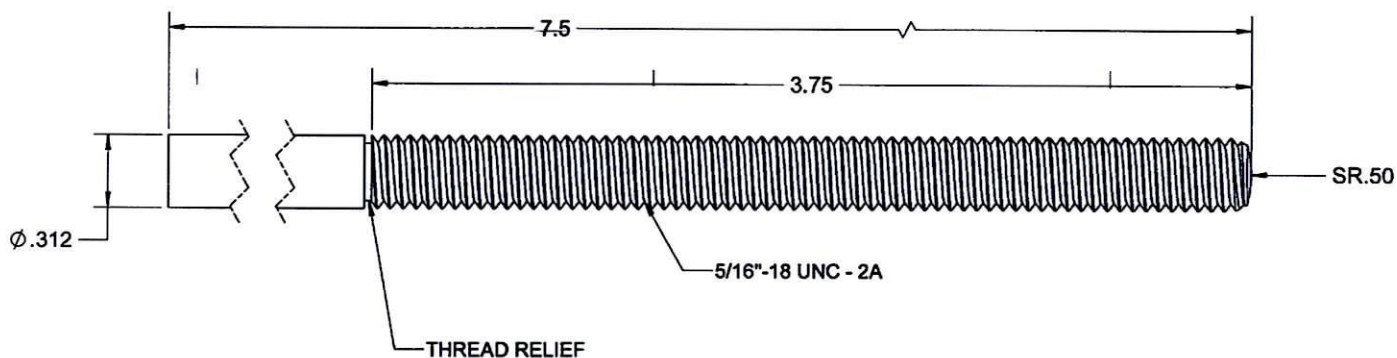
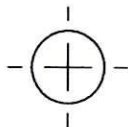
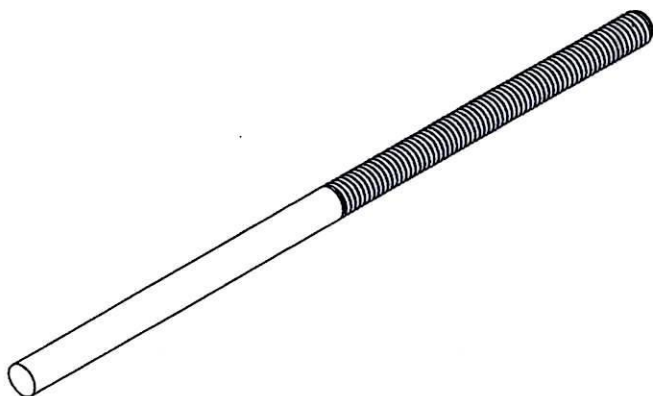
RB T101338-3 JACK SCREW



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATED
- 4) SPEC: ASTM B633 TYPE I, SC2
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A

DART AEROSPACE Newbury, Ontario, Canada	
JACK SCREW	
DWS NO. RB T101338-3	
DESIGN BY: VM 8/30/2017	JACK 2.063 FRACTIONS 5/16
DRAWN BY: VM 10/30/2017	3X ±.01 ANGLES 5.3°
CHECKED: SAC 10/30/2017	1. DIMENSIONS ARE IN INCHES
MFG. APPR: DD 10/31/2017	2. INTERPRET DIM AND TOL PER
APPROVED: VM 12/05/2017	3. DIMENSIONAL LIMITS APPLY
DATE: 10/30/2017	AFTER PLATING
SCALE: NTS	WEIGHT: N/A
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RB T101338-5 SCREW HANDLE

NOTES:

- 1) MATERIAL: AISI 4130
- 2) FINISH: N/A
- 3) HEAT TREAT: 36-40 Rc
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: N/A

DART AEROSPACE Newbury, Ontario, Canada	
SCREW HANDLE	
RB T101338-5	
DESIGN BY: VM 8/30/2017	REV A
DRAWN BY: VM 10/30/2017	
CHECKED: SAC 10/30/2017	
MFG. APPR: DD 10/31/2017	
APPROVED: DWM 12/06/2017	
DATE: 10/30/2017	
SCALE: NTS	WEIGHT: 0.1 LBS
SHEET 3 OF 4	
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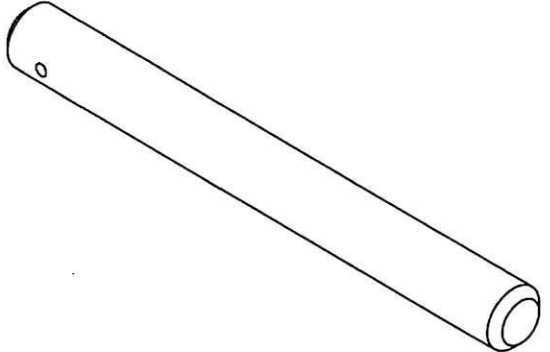
8 7 6 5 4 3 2 1

D

C

B

A

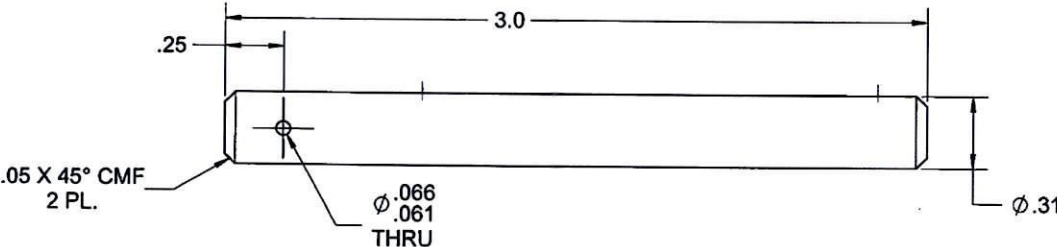


D

C

B

A



RB T101338-7 HANDLE

- NOTES:
- 1) MATERIAL: AISI 4130
 - 2) FINISH: N/A
 - 3) HEAT TREAT: 36-40 Rc
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A

8 7 6 5 4 3 2 1

DART AEROSPACE Newbury, Ontario, Canada			
TITLE HANDLE			
DWG NO. RB T101338-7			REV A
DESIGN BY:	VM 8/30/2017	XXX .005 FRACTIONS & 1/8	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED 2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 3. DIMENSIONAL LIMITS APPLY AFTER PLATING
DRAWN BY:	VM 10/30/2017	XX 1/16 ANGLES 5:5	
CHECKED:	SAC 10/30/2017	X 1/32 SURFACES = 10	
DATE:	10/30/2017		
APPROVED:	VM 12/08/2017		
SCALE:	NTS	WEIGHT: 0.1 LBS	SHEET 4 OF 4
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038767

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO038767

PO Date: 1/11/18

Due Date: 1/22/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED
JAN 15 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items									
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)
1	169386	647.7701	Strut Assembly Issue P/O : _____ Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread	Firmed	1/22/18	10 pcs	0 pcs	10 pcs	\$6.00/pcs
						✓ 10x			AT 18/02/05
2	169387	647.7702	Strut Assembly Issue P/O : _____ Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread	Firmed	1/22/18	10 pcs	0 pcs	10 pcs	\$6.00/pcs
						✓ 10x			AT 18/02/05
3	169877	647.2511	Nut Issue P/O: _____ Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformaty is required	Firmed	1/22/18	10 pcs	0 pcs	10 pcs	\$2.3809523/pcs
						✓ 10x			AT 18/02/05
4	169400	647.8511	Insert -Issue P/O to Groupe Altech: P/O -Passivate, MIL-S-5002 TYPE 6 AS PER DWG - Certificate of Conformity is required	Firmed	1/22/18	11 pcs	0 pcs	11 pcs	\$2.3809523/pcs
						✓ 11x			AT 18/02/05
5	169401	647.8512	Insert -Issue P/O to Groupe Altech: P/O -Passivate, MIL-S-5002 TYPE 6 AS PER DWG - Certificate of Conformity is required	Firmed	1/22/18	21 pcs	0 pcs	21 pcs	\$2.3809523/pcs
						✓ 21x			AT 18/02/05

PURCHASE ORDER

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	169271	RB	Jack Screw	Firmed	1/22/18	3 pcs	0 pcs	3 pcs	\$30.00/pcs	\$90.00
		T101338-3	-Issue P/O to Groupe Altech: P/O				3x		ATC 8/24/14	
			-Zinc plate, ASTM B633 TYPE 1							
			SC2							
			-Certificate of Conformity is required							
									Grand Total:	\$310.00
Order Notes										
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

Plex 1/15/18 11:04 AM dart.lavoie.chantal



Certificat de Conformité / Certificate of Compliance

(005811-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

005811- 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courtier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
22-Jan-2018		Curtis Anderson		PO038767				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	647.7701 Rev.	647.7701 CAD PLATE IAW QQ-P-416F CLASS 1 TYPE 2 CAD PLATE SHOULD NOT BE TOO THICK AROUND TREAD	CADMIUM CH	10	10	0	0	0
2	647.7702 Rev.	647.7702 CAD PLATE IAW QQ-P-416F CLASS 1 TYPE 2 CAD PLATE SHOULD NOT BE TOO THICK AROUND TREAD	CADMIUM CH	10	10	0	0	0
3	647.2511 Rev.	647.2511 PASSIVATION PASSIVATION AS PER MIL-S-5002 TYPE 6	PASSIVATION CH	10	10	0	0	0
4	647.8511 Rev.	647.8511 PASSIVATION PASSIVATION MIL-S-5002 TYPE 6	PASSIVATION CH	11	11	0	0	0
5	647.8512 Rev.	647.8512 PASSIVATION PASSIVATION MIL-S-5002 TYPE 6	PASSIVATION CH	21	21	0	0	0
6	RBT101338-3 Rev.	RBT101338-3 ZINC PLATE ,ASTM B633 TYPE 1 SC2	ZINC CH	3	3	0	0	0

Notes Additionnelles / Additional Notes

CAD PLATE SHOULD NOT BE TOO THICK AROUND TREAD

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements
 Our financial and legal responsibility will not be higher than the amount of invoice.